Thursday, 8/30/2007 3:51:02 PM

User:

Kim Johnston

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 34357

Estimate Number

: 10271

P.O. Number

: N/A

This Issue Prsht Rev.

: NC

S.O. No. : NA : 8/30/2007

: 32403

: SMALL /MED FAB

Project Number **Drawing Revision**

Drawing Number

Part Number

Drawing Name

Material **Due Date** : NA

: N/A

: LUG

: D2561

D2561 REV B

: 9/21/2007

Qty:

Each

Written By

First Issue

Previous Run

Checked & Approved By Comment

: Est

00.05.19 Added inspect level 8 EC

Est Rev:D Now on Waterjet 06-06-14 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6B0250X06000

6061-T6 Bar .25" x 6.0"



Comment: Qty.:

0.3850 f(s)/Unit Total:

19.2518 f(s)

Material:6061-T6, or 5052-H34 6.00" x 0.25" Thick Batch: M 100 782-56 IR 07 -09-01

FLOW WATER JET



WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D2561

07-09-01

2-Deburr if necessary

SM

56

3.0



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

40

QC8

SECOND CHECK

Comment: SECOND

SMALL FAB 1



5.0

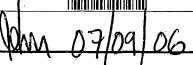
SMALL & MEDIUM FAB RESOURCE 1





Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr, no sharp edges



Dart Aerospace Ltd

W /O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr QC Inspec	oval ector								
_											

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: 9769 (14)
			QA: N/C	losed:	Date:

NCR:	-	WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description	ion Description Sign & Verific		Approval Chief Eng	Approval QC Inspector				
osloulo	2.0	One part scrap, tab on part was cut in side the part instead of cutting out side.	Siwz	Scarap. destray - replace Fix prog	Date SAN 07/04/04		Pasivir	of office				
					7			(0				

NOTE: Date & initial all entries

Date:

Thursday, 8/30/2007 3:51:02 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 34357

Part Number: D2561

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

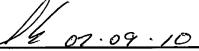
PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: WA



7.0

FINAL INSPECTION/W/O RELEASE



56

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

Dan Ae	rospace Ltd							
W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
******						, -		
				·				
Part No	:	PAR #:	Fault Category:	NCR: Ye	es No DQ	A:	Date:	
	,			QA	: N/C Close	d:	Date: _	
NCR:			WORK ORDER NON-COI	NFORMANCE (NO	CR)			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	A			
DATE ST	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector			
		•									
							v				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34351
Description: Lug Plate	Part Number:	D2561
Inspection Dwg: D2561 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Arti	icle	Prot	otype
wing	Tolerance	Actual	Accept	Reject	Method

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	0.502	-		Vern	
2.025	+/-0.010	2.029	L		Ven	
3.975	+/-0.010	3.985			Vern	
Ø0.257	+0.005/-0.000	80,260			Vern	
4.025	+/-0.010	4.033	/		Vern	
5.025	+/-0.010	5032	1		Vern	
0.25	+/-0.030	5032			Vers	
	470-4-4					
		,				
						44
						112 - 102 - 102
						1771-1
	Paradon and a second			· · · · · · · · · · · · · · · · · · ·		
				:		
		Α,				

Measured by: Audited by: Prototype Approval: N/A		\frown			
	y: Prototype Approval: N/A	En ,	Audited by:	\\\\\\\	Measured by:
Date: Date: Date: Date:	9: \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	102/04	Date:	DIE Ways	Date:

Rev	Date	Change	Revised by	Approved
Α	04.01.21	New Issue	KJ/RF	
				



DESIGN B WILLIAMS	DRAWN BY	DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT,			
CHECKED	APPROVED	DRAWING NO.		REV.	В
Bri	86	D2561	SHEET		- 1
DATE	J	TILE		SCA	LE
96.04.26		LUG PLATE			1:1

